

Date: Thursday, 4/12/2007 8:22:31 AM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : SUPPORT ASSEMBLY
Job Number : 31661	
Estimate Number : 10464	
P.O. Number : <i>N/A</i>	Part Number : D3278041
This Issue : 4/12/2007 S.O. No. : <i>N/A</i>	Drawing Number : D3278 REV. B
Prsht Rev. : NC	Project Number : N/A
First Issue : <i>N/A</i> Type : SMALL /MED FAB	Drawing Revision : B
Previous Run : 30563	Material : <i>N/A</i>
Written By : _____	Due Date : 4/22/2007 Qty: 40 Um: Each
Checked & Approved By : <i>[Signature]</i> 07.04.12	
Comment : Est:A 04.04.19 New issue KJ/JLM	

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 31661A SUPPORT



B31661A x 33

Not in inv.



Comment: Sub-Component SUPPORT

D3278-1 B ~~305~~ 30563 A x 7 ✓

2.0 31661B SUPPORT



B31736 x

Not in inv.



Comment: Sub-Component SUPPORT

D3278-2 B 30563 B x 13 ✓

3.0 D32783 Spacer



Comment: Qty.: 1.0000 Each(s)/Unit Total: 40.0000 Each(s)

Spacer

Pick:

Qty Part Number Description Batch

1 D3278-3 Spacer

B31941 x 39

Not in inv.

B30291 x 1 ✓

4.0 MS20426AD37 RIVET



Comment: Qty.: 4.0000 Each(s)/Unit Total: 160.0000 Each(s)

RIVET

Pick:

Qty Part Number Description Batch

4 MS20426AD37 Rivet

D3-6 07.04.26

M4533 M16527

m07/04/26

5.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Rivet spacers with support as per Dwg D3278.

m07/04/26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 4/12/2007 8:22:31 AM
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Drawing Name: SUPPORT ASSEMBLY

Job Number: 31661

Part Number: D3278041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB

07/04/27 (40)

7.0

D22301

Mounting Lug



Comment: Qty.: 2.0000 Each(s)/Unit Total : 80.0000 Each(s)

Mounting Lug

Pick: Packing Kit

Qty Part Number

Description

Batch

2 D2230-1

Mounting Lug

B30155

x61

(*) B 30992 (29)

8.0

AN413A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 80.0000 Each(s)

Bolt

Pick: Packing Kit

Qty Part Number

Description

Batch

2 AN4-13A

Bolt

M103363

✓

9.0

AN960JD416

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 160.0000 Each(s)

Washer

Pick: Packing Kit

Qty Part Number

Description

Batch

4 AN960JD416

Washer

M102929

✓

10.0

MS21042L4

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 80.0000 Each(s)

Nut

Pick: Packing Kit

Qty Part Number

Description

Batch

2 MS21042L4

Nut

M103914

✓
M1007/05/02

11.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble support as per Dwg D3278.

DO NOT TIGHTEN BOLTS

Identify as D3278-041

x40

M1007/05/02

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Ⓜ Date: 07/05/03

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SUPPORT ASSEMBLY

Job Number: 31661

Part Number: D3278041

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB

07/05/02

(40)

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

W

7/5/2 59

14.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

207/05/03

(40)

Job Completion



U 07/05/03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

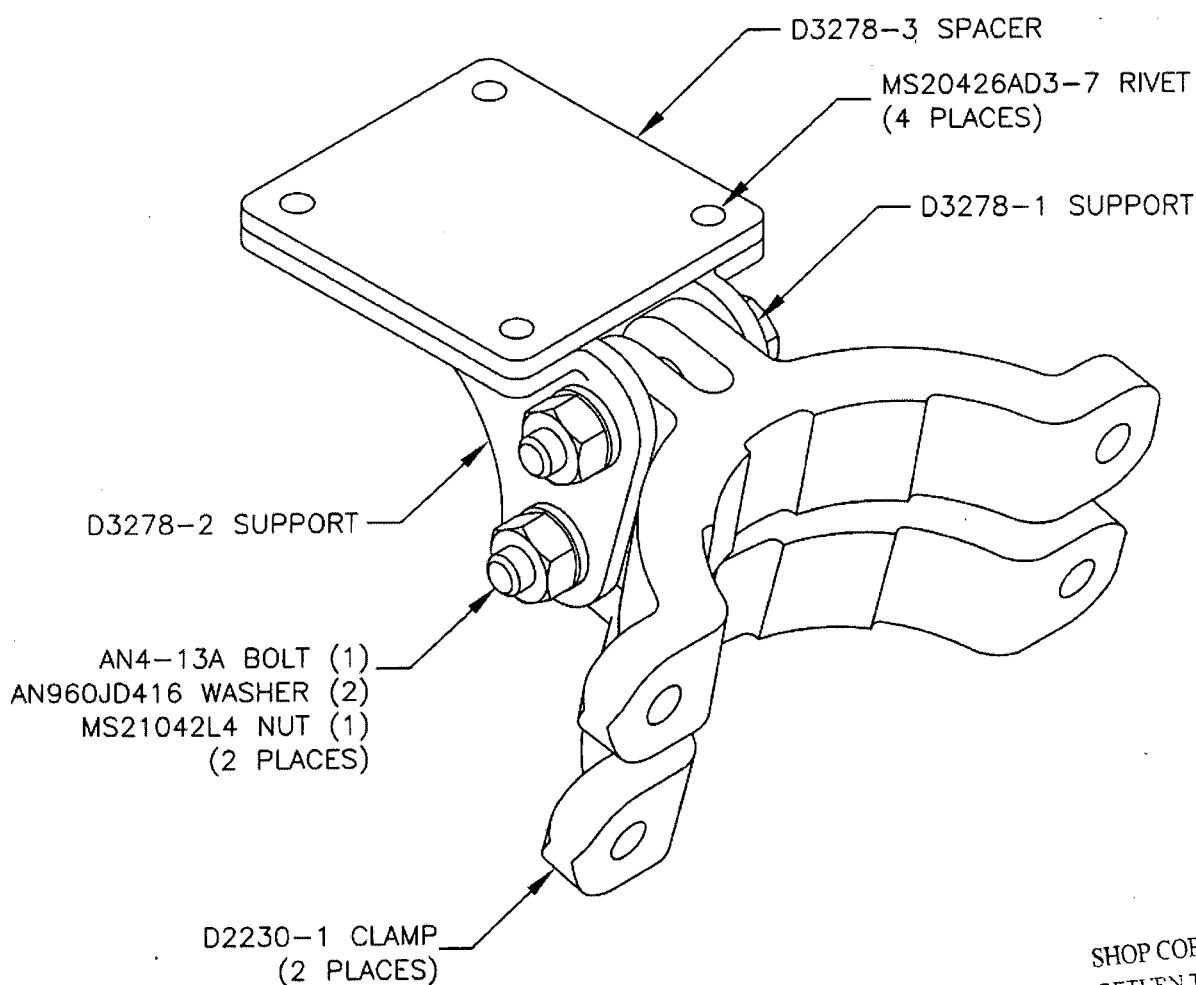
NOTE: Date & initial all entries



DESIGN	CP	DRAWN BY	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	#	APPROVED	#	DRAWING NO. D3278	REV. B SHEET 1 OF 3
DATE	05.03.31			TITLE SUPPORT ASSEMBLY	SCALE NTS
A	04.03.03			NEW ISSUE	
B	05.03.31			CHANGE DIM/TOL TO ENSURE FIT	

RELEASED
05.04.04

D3278-041 SUPPORT ASSEMBLY



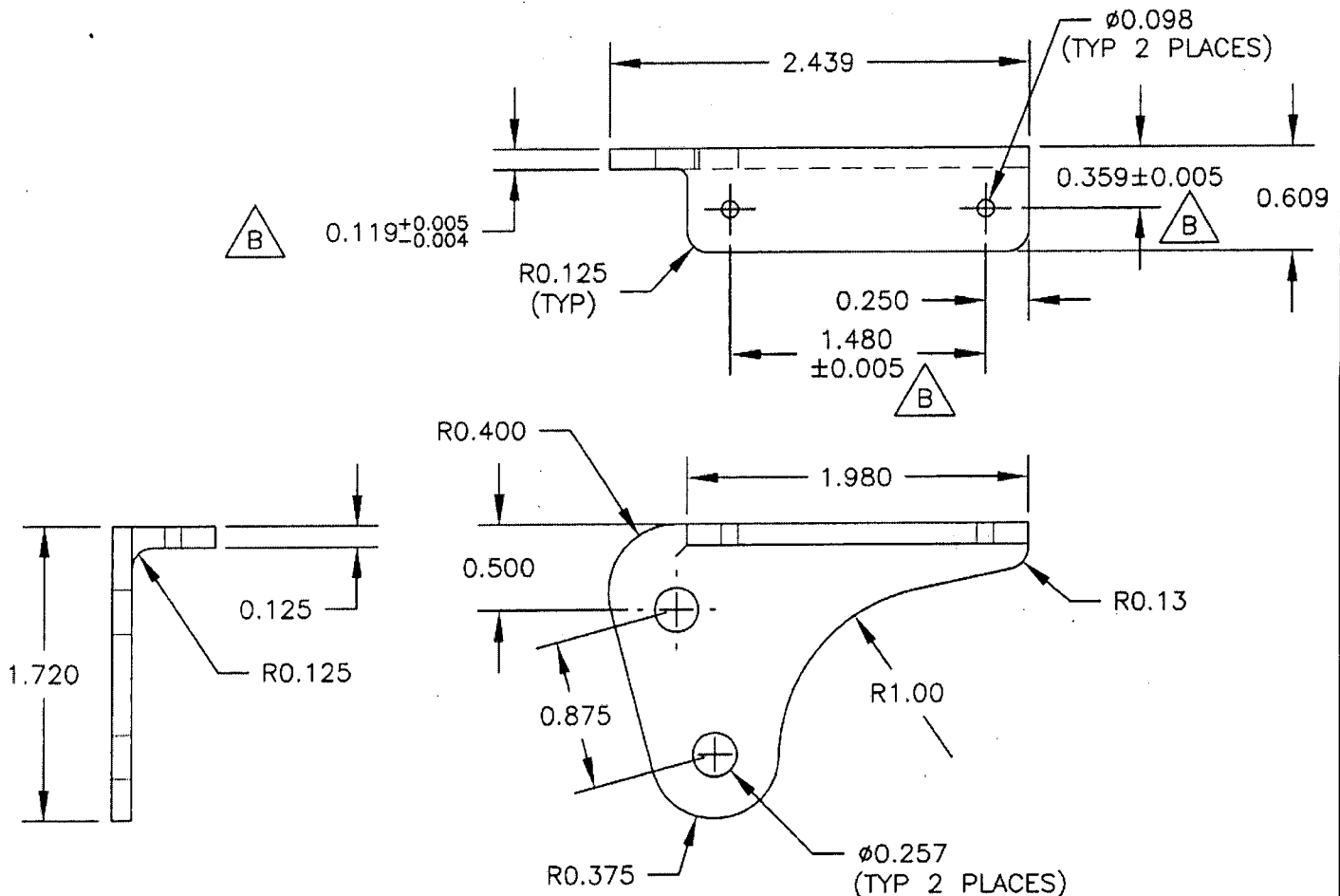
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DATE 05.03.31	TITLE SUPPORT ASSEMBLY		SCALE 1:1

RELEASED05.04.04 *[Signature]*

D3278-1 SUPPORT (SHOWN)

D3278-2 SUPPORT (OPPOSITE)

- 1) MACHINE PER DWG FILE "D3278-1.SLDPRF"
- 2) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-250/8 OR QQ-A-250/110)
(REF DART SPEC. M6061T6B OR M6061T6S)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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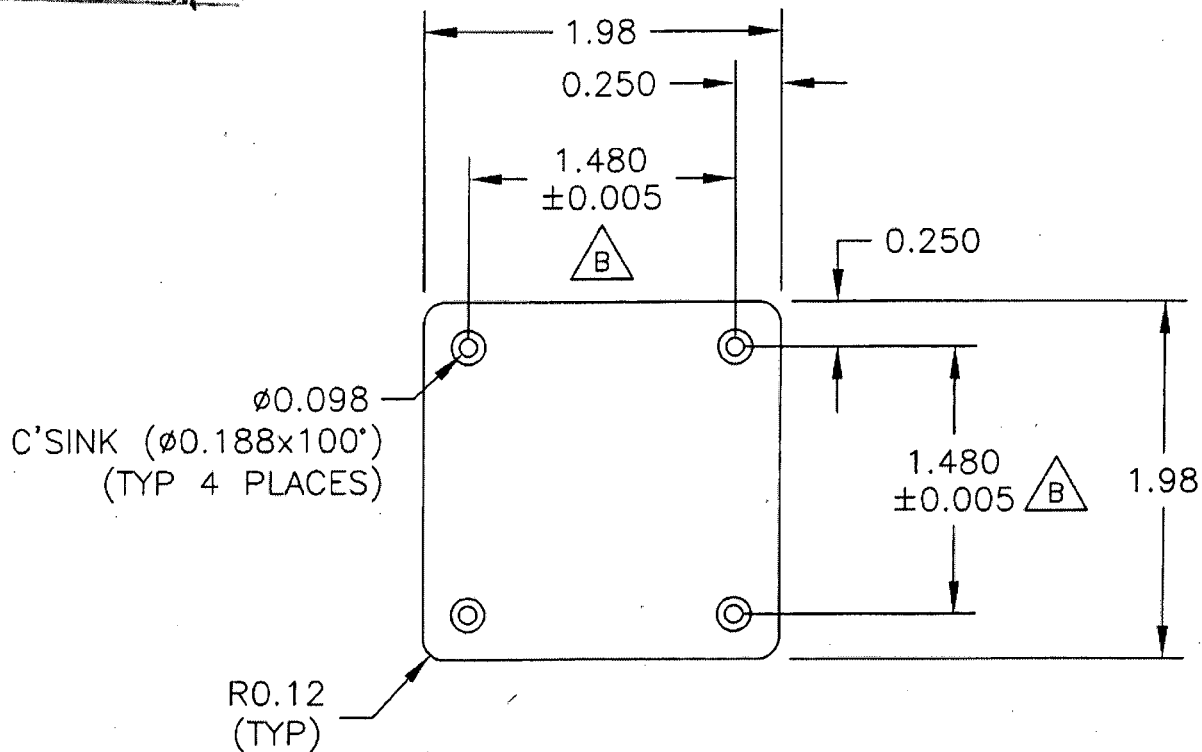
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DATE 05.03.31		TITLE SUPPORT ASSEMBLY	SCALE 1:1

RELEASED
05.04.04 *[Signature]*



D3278-3 SPACER

- 1) MATERIAL: BLACK DELRIN / UHMW PER DART SPEC M-DELIN-B OR M-DELIN-S
0.125 THICK
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) ALL DIMENSIONS ARE IN INCHES.

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